

Date: Thursday, 29/05/2008 11:04:59 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: CAP		
Job Number	: 39562			Part Number	: D2855		
Estimate Number	: 10519			Drawing Number	: D2855 REV. A		
P.O. Number	:			Project Number	: N/A		
This Issue	29/05/2008	S.O. No.	:	Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	/: /	Type	: PURCHASED PARTS			Due Date	: 10/06/2008
Previous Run	: 38395			Qty:	30	Um:	Each
Written By	:						
Checked & Approved By	: <u>DU 08.5.29</u>						
Comment	: Est: B 00.06.22 Added receiving step & removed P/O for powder coat EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		 Comment: PURCHASING Issue P/O: <u>6469</u> Cast per Dwg D2855 Material Release Note Required
2.0	D2855P	Cap
		 Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s) CAP
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached
4.0	QC6	DIMENSIONAL CHECK
		 Comment: DIMENSIONAL CHECK <p style="text-align: right;"><u>5/05/08</u> <u>18:30</u> <u>Coates</u></p>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Drill as per Dwg D2855 using DT8235 2- Open holes to 19/64" 3- Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 29/05/2008 11:04:59 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 39562

Part Number: D2855

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



S 08/06/23 X38
coated

Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING POWDER COATING



~~7/06/23/6~~

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

N107425

9/1 08-06-24 X30

30

START TIME: 8:35 8:50

OVEN TEMPERATURE: 320°

FINISH TIME: 8:45 9:20AM

~~7/06/23/6~~

~~7/06/23/6~~

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

F1 08/06/24

30

9.0 ALS71032225 INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 60.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

m100489.

2 ALS7-1032-225 Insert

or AKS7-1032-225

or ALS4-1032-225

or AKS4-1032-225

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



30

Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2855

F1 08/06/24

11.0 QC5 INSPECT WORK TO CURRENT STEP



coated

S 08/06/24 X38

Comment: INSPECT WORK TO CURRENT STEP

12.0 PACKAGING 1 PACKAGING RESOURCE #1



30

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-22

F1 08/06/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 29/05/2008 11:04:59 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 39562

Part Number: D2855

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

13.0 QC21 FINAL INSPECTION/W/O RELEASE



08/06/25 JY

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



-C08/06/25

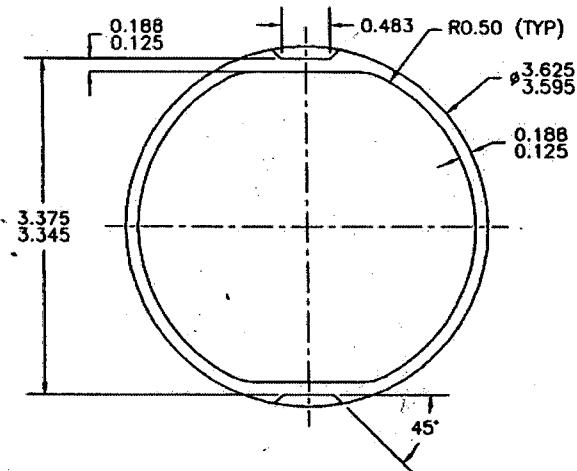
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

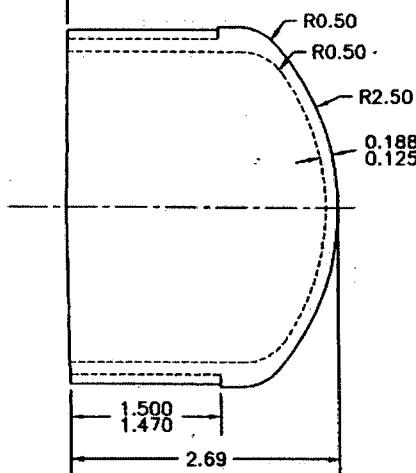
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

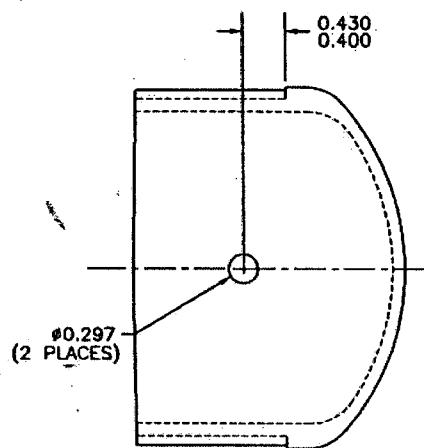
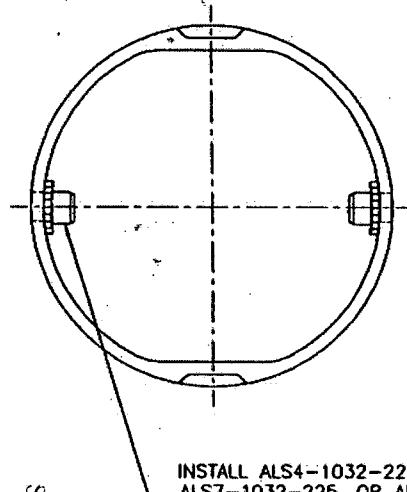
D2855 CASTING DETAIL



1° TAPER



D2855 FINISHING DETAIL



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
(2 PLACES)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
MATERIAL: CAST ALUMINIUM ALLOY A356.2 (F) *KG 99.09.12*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 381562

RELEASED
98.12.14 DS

DART

GA COPY
SHEET 1 OF 1

DESIGN	DRAWN BY	DART AEROSPACE LTD
98.12.12	98.12.12	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>GP</i>	<i>KE</i>	D2855
DATE	TITLE	SCALE
98.12.12	CAP	NTS
A	96.12.12	NEW ISSUE (WAS D2575 REV. E)

Aluminum Foundry Ltd

714-716 Calais
Dorval, Québec H9P 2P3
Tel: (514) 631-1331
Fax: (514) 631-8448

Packing Slip

Packing Slip No.: 32616
Date: Jun 17, 2008
Page: 1

Sold to:	Ship to:
DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7	DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7
Order No.: <u>00006489</u> 00006489	Sold By:
Shipped By:	Ship Date: Jun 17, 2008
Tracking No.:	

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A	30

Comment:

7CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

FONDERIE D'ALUMINIUM ET MODÉLERIE (1988) LTD
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

714-716 CALAIS, DORVAL, QC H9P-2P3
TEL: (514) 631-1331 FAX: (514) 631-8448

Expédié à
Shipped

DART AEROSPACE

A.F. & P.W. Série no./Serial no.

1270 Aberdeen Street

Packing
Date: 17/06/2008 Slip No. 32616

Hawbsury, ON, K6A 1K7

Votre No. Commande 00006489
Your order No. 00006489

Ceci est pour certifié que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificats d'usine sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
4030	D 2855 CAP	Z098046	A356.2	ingot#851118

Analysé
Analysis (as in ingot)

(Si)	7.00%	(Al)	balance
(Fe)	0.06%		
(Cu)	0.00%		
(Mn)	0.00%		
(Mg)	0.42%		
(Zn)	<0.01%		
(Ti)	0.16%		

Donne
Yield :

Résistance à la tension :
Tensile Strength :

Allongement par pouce carré :
P.S.I. Elongation : %

Pour et au nom de
For and on behalf of :

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTD
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

Dépt/Dép :
Par/Per :